



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

11283
Jan 2

25 JAN

RBT18520
Job Sheet 186719



Part No: RBT18520

Job Qty: 1 ea

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/28/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	1 pcs		12/28/18	0.08	0.33	Small Fab-9		MLC DAS
110	QC	1 pcs		12/28/18	0.00	0.00	QC5		JAN 04 2019 68
130	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging3-2		DAS 9-89
140	QC21-FG	1 Ea		12/28/18	0.00	0.00	QC21		DAS 28

Part Op 100 - Assemble

Descriptions: 130 - Identify and Stock

JAN 04 2019-89

GA213

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	100-Small Fab	5108536
20625A914	Dial Indicator Atchmnt Agd-2 Dial	1 Ea (1 ea)	100-Small Fab	5131311
5416K41	SS Hose Clamp 3.5" Dia.	1 Ea (1 ea)	100-Small Fab	5131313
90108A417	Flat Washer 3/8" Plated	2 Ea (2 ea)	100-Small Fab	5044121
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	1 Ea (1 ea)	100-Small Fab	5131313
92845A245	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length	2 Ea (2 ea)	100-Small Fab	5044124
93839A815	Hex Nut 3/8-24 Unf	2 Ea (2 ea)	100-Small Fab	5044120
95615A120	1/4-20 Nylock Nut	1 Ea (1 ea)	100-Small Fab	5044123
AGD-2	1" Dial Indicator 0" to 1" Range	1 Ea (1 ea)	100-Small Fab	5089136
FPSC4-10R	TBD	1 Ea (1 ea)	100-Small Fab	5044352
FPSC5-10R	TBD	1 Ea (1 ea)	100-Small Fab	5044353
RBT18520-1	Lift Device Frame	1 Ea (1 ea)	100-Small Fab	5132092
RBT18520-11A	Weight Assembly	1 Ea (1 ea)	100-Small Fab	5140528
RBT18520-15	Clevis Bracket	1 Ea (1 ea)	100-Small Fab	5049449
RBT18520-16	Indicator Bracket	1 Ea (1 ea)	100-Small Fab	5051540
RBT18520-5	Weldment	1 Ea (1 ea)	100-Small Fab	5107082
RBT18520-7	Pivot Bar Weldment	1 Ea (1 ea)	100-Small Fab	5053641
RBT18520-9A	Extension Assembly	2 Ea (2 ea)	100-Small Fab	5136174

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	10164	1	6	0
	20625A914	1	0	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

5416K41	1	6	0
90108A417	2	92	0
91259A583	1	4	0
92845A245	2	17	0
93839A815	2	42	0
95615A120	1	96	0
AGD-2	1	1	0
FPSC4-10R	1	6	0
FPSC5-10R	1	6	0
RBT18520-1	1	2	0
RBT18520-11A	1	0	0
RBT18520-15	1	2	0
RBT18520-16	1	2	0
RBT18520-5	1	2	0
RBT18520-7	1	2	0
RBT18520-9A	2	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/18 1:30 PM Dart.lajeunesse.marie



Container No: S141411



Part: RBT18520

Job No: 186719

Serial No/Batch: S141411

Revision: 11

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/03/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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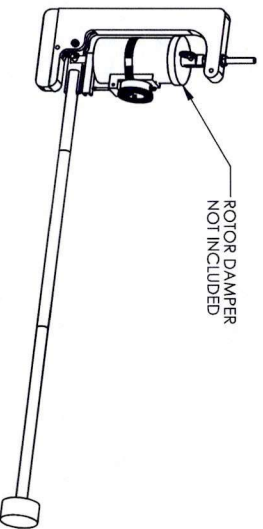
ROTOR DAMPER
NOT INCLUDED

EXPLODED VIEW

RETURN
ENGINEER
UNCONTROL
SUBJECT TO AM
WITHOUT
WORK O
NO. 1867

9m5
18-11-20

Pg.	B/O INFORMATION OR SPECIFICATIONS									
	UNIT	Description	Material							
2	1	FRAME	6061							
3	-3	TOP BOLT TAB	1018/1020 CR							
4	-5	TOP BOLT WELDMENT								
5	-5A	ALL THREAD	STEEL							
6	-6	JAM NUT	STEEL							
7	-6A	PLA WASHER	STEEL							
8	-7	INCOI BAR WELDMENT								
9	-7A	INCOI BAR TAB	1018/1020 CR							
10	-8	TUBE	CDS							
11	-9	EXTENSION	CDS							
12	9A	EXTENSION ASSEMBLY								
13	-10	SOCKET HEAD SET SCREW	STEEL							
14	-11	WEIGHT	BRASS							
15	-11A	WEIGHT ASSEMBLY								
16	-12	SOCKET HEAD SHOULDER BOLT	STEEL							
17	-12A	NYLON LOCK NUT	STEEL							
18	-13	QUICK RELEASE PIN	3.5.							
19	-14	QUICK RELEASE PIN	3.5.							
20	-15	CLEVIS BRACKET	6061							
21	-16	INDICATOR BRACKET	6061							
22	-17	SOCKET HEAD SET SCREW (DOG POINT)	3.5.							
23	-18	HOSE CLAMP	3.5.							
24	-19	1 1/4 DIA INDICATOR								
25	-20	PLA BACK FOR DIA INDICATOR	PLASTIC							
26	-23	LARGE PISTOL CASE								
N/S										

[illegible]

—ROTOR DAMPER
NOT INCLUDED

NOTE:  CALIBRATED UPON CUSTOMER REQUEST.

ART

DAMPER TEST DEVICE

RB T18520

SCALE	1:8	DATE	8/17/2000	SHEET 1 OF 17
QA APPR:	LINDSAY			
DESIGN BY:	COLE			
CHECKED:	MACKOVLYAK			
3RD APPR:	ANDERSON			
DESIGN BY:	COLE			
QA APPR:	LINDSAY			
SCALE	1:8	DATE	8/17/2000	SHEET 1 OF 17



Chicago Dial Indicator Co.
1372 Redeker Road
Des Plaines, IL 60016
ISO Registered Firm

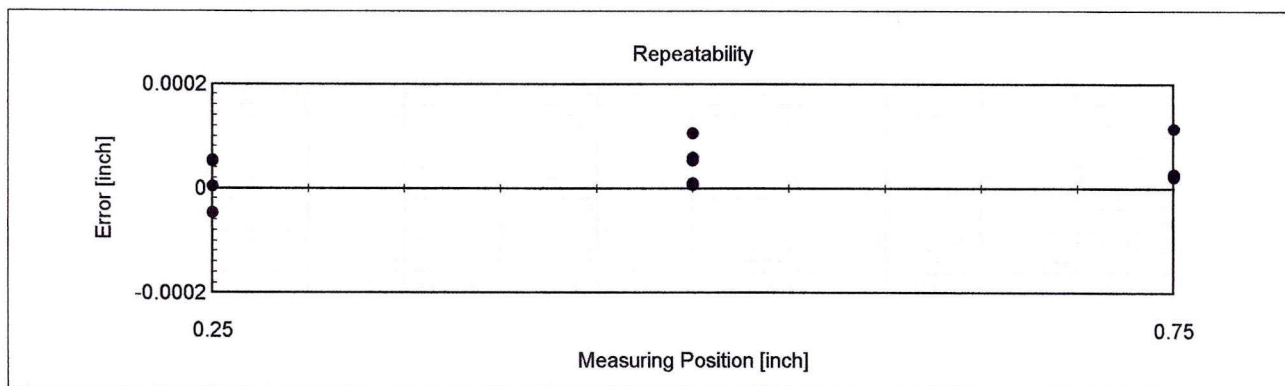
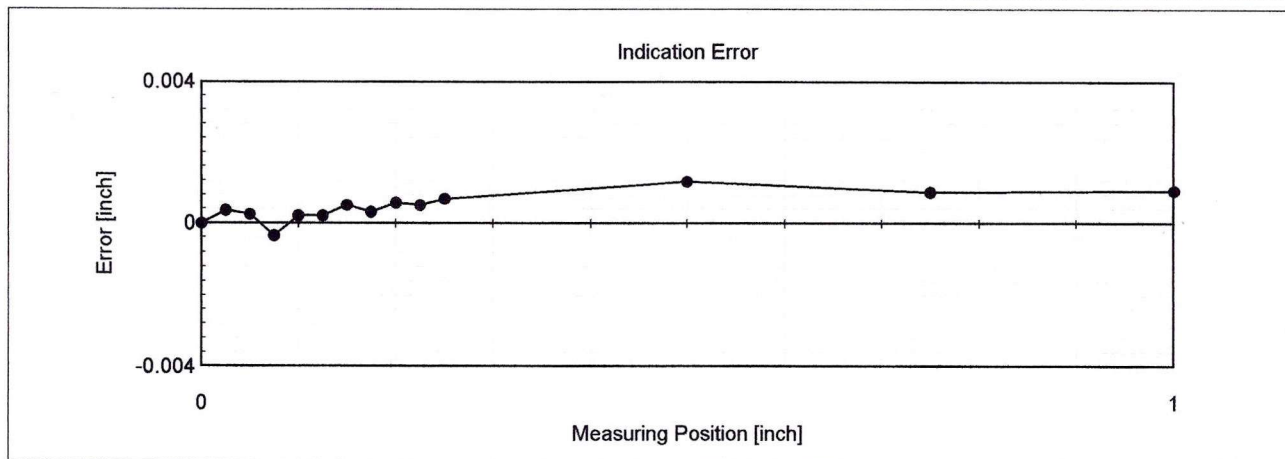
Factory Certificate of Calibration

Model No.	26104B	Name of Inspection Standard	CDI Mechanical Standard
Serial No.	181387484	Unit	inch
Certificate No.	63990	Scale Interval	0.001 inch
		Measuring Range	1 inch
		Reference Point	0 inch
		End Point	1 inch

N.I.S.T. No. 821/268795-03

Inspection Item Name	Result	Permissible Value	Judgment
First 2-1/3 Revolutions	+0.00066 inch	± 0.001 inch	GO
First 10 Revolutions	+0.0011604 inch	± 0.002 inch	GO
First 20 Revolutions	-----	-----	N/A
Hysteresis	-----	-----	N/A
Repeatability	+0.0001142 inch	± 0.0002 inch	GO

Inspection Item Name	Judgment
Inspection of Function and Appearance	GO



Repeatability is taken at three positions, with five readings at each position.

Phone: 847-827-7186
Fax: 847-827-0478
Website: www.dialindicator.com

Date _____
Put into service date, provided by end user

Signature: *[Signature]*